



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2535**Job Sheet 205729**

131

Part No: D2535**Job Qty:** 130 pcs**Part Name:** Spring**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/16/20**Job Tracking No:****Due Date:** 1/30/20**Created By:** Chantal Lavoie**Type:** Stock**Description:****Note:** DWG REV A IPP A 99.04.19 New Issue (From hand written IPP) DM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing JAN 16 2020	DAS 130	1/30/20	1/30/20	0.00	0.00	Purchasing - 1	JAN 27 2020	
		13 pcs							
		2-88 PO 4B045596							
110	Packaging 2-1 - Receive - B4B	130 pcs	1/30/20	1/30/20	0.00	0.00	Packaging 2 - 1 - B4B	JAN 27 2020	
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S251029**Part:** D2535**Job No:** 205729**Serial No/Batch:** S251029**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 01/27/20

Plex 1/16/20 12:17 PM Dart.Lavoie.Chantal

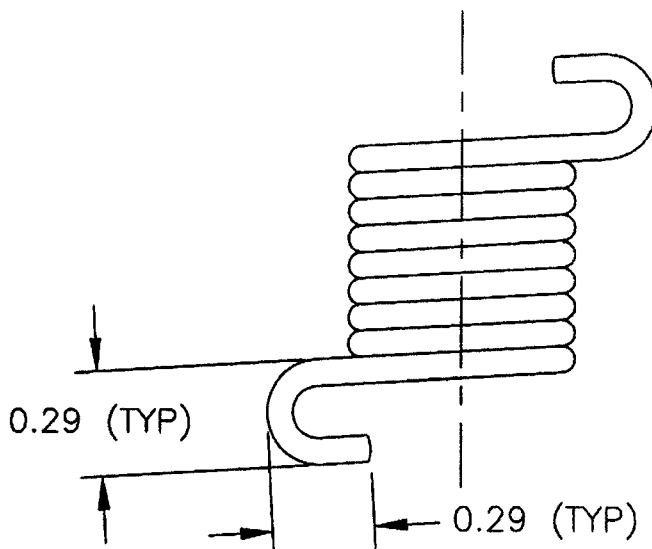
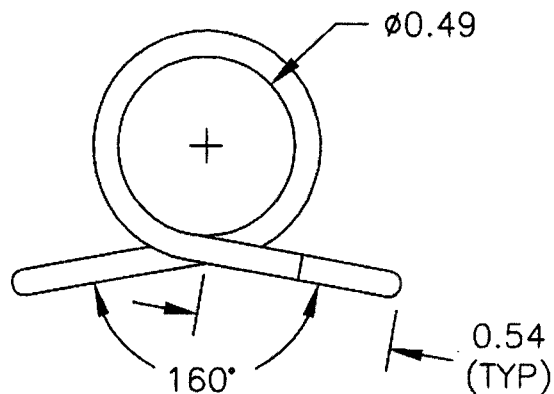
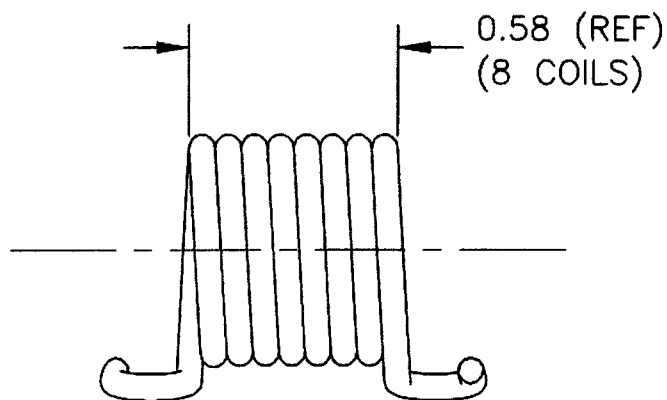
				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
120 QC 6	130 pcs	1/30/20	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	JAN 31 2020 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	130 pcs	1/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	BEB20-01-31
				Plex 1/16/20 12:17 PM Dart.Lavoie.Chanta	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	130 pcs	1/30/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21
Part Op 100 - (Purchasing) Issue P/O: _____ Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached 120 - (QC6- All purchased or subcontracted products) Check dims to dwg 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item D2535P	Component Name Spring	Quantity 130 pcs (1 ea)	Operation 100-Purchasing	Container S&S 1077	
Job Allocations					
Operation 100-Purchasing	Component Part D2535P	Required 130	Inventory 0	Allocated 0	
Part Specifications					
Specifications could not be found.					



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045596



Supplier: VIC002-VC
Victory Spring Ltd.
3810 - 51 Ave.
Edmonton
AB
T6B 3T5 Canada
Phone: 780 442 4020
Fax: 780 466 8000

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045596

PO Date: 1/16/20

Due Date: 2/19/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

JAN 16 2020

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D2535P	D2535 REV. A		Spring : AS PER DWG D2535 REV. A	Firmed X130	-	1/24/20	130 pcs	0 pcs	130 pcs	\$1.90/pcs	\$247.00
													JAN 27 2020
2		D2535P	D2535 REV. A		Spring : AS PER DWG D2535 REV. A	Firmed	-	2/19/20	170 pcs	0 pcs	170 pcs	\$1.90/pcs	\$323.00
Grand Total:													\$570.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 1/16/20 12:49 PM Dart.Lavoie.Chantal

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace Ltd.	DATE: 1/21/2020																						
PART/DRAWING #: VIC 1533 / D2535P	PO # pohb045596																						
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 130																						
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03																							
PROPERTIES: <table> <thead> <tr> <th><u>Chemical</u></th> <th><u>Physical</u></th> </tr> </thead> <tbody> <tr> <td>Carbon: (C) 0.065</td> <td>Size: 0.072"</td> </tr> <tr> <td>Chromium: (Cr) 18.050</td> <td></td> </tr> <tr> <td>Copper: (Cu) 0.420</td> <td>Tensile PSI: 268,300 / 275,000</td> </tr> <tr> <td>Manganese: (Mn) 1.190</td> <td></td> </tr> <tr> <td>Molybdenum: (Mo) 0.330</td> <td></td> </tr> <tr> <td>Nickel: (Ni) 8.020</td> <td></td> </tr> <tr> <td>Phosphorus: (P) 0.029</td> <td>Heat # KNAX00924</td> </tr> <tr> <td>Silicon: (Si) 0.320</td> <td></td> </tr> <tr> <td>Sulphur: (S) 0.001</td> <td></td> </tr> <tr> <td colspan="2">Mill Source: Gibbs Wire</td> </tr> </tbody> </table>		<u>Chemical</u>	<u>Physical</u>	Carbon: (C) 0.065	Size: 0.072"	Chromium: (Cr) 18.050		Copper: (Cu) 0.420	Tensile PSI: 268,300 / 275,000	Manganese: (Mn) 1.190		Molybdenum: (Mo) 0.330		Nickel: (Ni) 8.020		Phosphorus: (P) 0.029	Heat # KNAX00924	Silicon: (Si) 0.320		Sulphur: (S) 0.001		Mill Source: Gibbs Wire	
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Mill Source: Gibbs Wire																							

Certified by: Jeremy Burrowes - QA

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 1/21/2020
PART/DRAWING #: D2535P / VIC 1533	PO # pohb045596
DESCR: Torsion Spring	QUANTITY: 130

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	.489"	
Coil O.D.		.634"	
Number of Coils	8 ref	7.9	
Overall Length		1.109	
End Type	per dwg	yes	
Helix	RHW	RHW	

COMMENTS

Mill Certificate attached: Yes
Material Heat Number: KNAX00924

DAS
68
9-89

Inspected by: *Jeremy Burrowes*



3810 - 51 Ave
Edmonton, AB T6B 3T5
t + 780 442 4020
e + accounts@victoryspring.ca

PACKING SLIP

Packing Slip: 45984
Date: Jan 20, 2020
Order Ref: POHB045596

Sold to:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship to:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Shipped By: FedEx

Shipped Quantity	Backorder Quantity	Unit	Item No.	Description	Price
130	170	Each	VIC 1533	D2535P Spring - Torsion	1.90
		Each	VIC 1533	D2535P Spring - Torsion	1.90
RECEIVED JAN 27 2020 DART AEROSPACE LTD.					
Comment:					